

**ABSTRACT**

A press tool for closed die forging a blank into a product is described. Said tool including upper and lower centre members ~~(21, 22)~~ and first ~~(23, 24)~~ and second ~~(25, 26)~~ side members. Said members define a cavity with the form of the product. In a two-step closed die forge process the blank ~~[(20)]~~ is placed between said upper and lower centre members ~~(21, 22)~~. The first ~~(23, 24)~~ and second ~~(25, 26)~~ side members are forced against the blank ~~[(20)]~~ horizontally upsetting the outer edges of the blank. Then, the centre members are forced vertically into the blank, until the material in the blank has substantially filled the cavity.